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D4021-9**Job Sheet 191399****Part No:** D4021-9**Job Qty:** 60 pcs**Part Name:** Bushing**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/28/19**Job Tracking No:****Due Date:** 3/22/19**Created By:** Marie Lajeunesse**Type:** ~~Stock~~ *SOLD***Description:**

Note: DWG REV B SHEET 3 IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP Rev:B as per dwg REV.A
DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	60 pcs	3/22/19	3/22/19	0.00	3.26	Hardinge - 1		JRD 19/03/15
120	QC 8	60 pcs	3/22/19	3/22/19	0.00	0.00	QC 8 - 12		PML 19/03/16
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
130	Packaging 3-1 - Stock - B4B	60 pcs	3/22/19	3/22/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		

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				Packaging 3 - 8 - B4B							
				Packaging 3 - 9 - B4B							
				Packaging 3 - 10 - B4B							
				Packaging 3 - 11 - B4B	MAR						
				Packaging 3 - 12 - B4B							
				Packaging 3 - 13 - B4B							
				Packaging 3 - 14 - B4B							
				Packaging 3 - 15 - B4B							
				Packaging 3 - 16 - B4B							
				Packaging 3 - 17 - B4B							
				Packaging 3 - 18 - B4B							
				Packaging 3 - 19 - B4B							
				Packaging 3 - 20 - B4B							
				Packaging 3 - 21 - B4B							
				Packaging 3 - 22 - B4B							
				Packaging 3 - 23 - B4B							
				Packaging 3 - 24 - B4B							
				Packaging 3 - 25 - B4B							
				Packaging 3 - 26 - B4B							
				Packaging 3 - 27 - B4B							
				Packaging 3 - 28 - B4B							
				Packaging 3 - 29 - B4B							
				Packaging 3 - 30 - B4B							
				Packaging 3 - 31 - B4B							
				Packaging 3 - 32 - B4B							
				Packaging 3 - 33 - B4B							
				Packaging 3 - 34 - B4B							
				Packaging 3 - 35 - B4B							
				140	QC 21 - SA	60 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21	DAS 21 2-85	MAR 18 201
									QC 21 - SA - 70		
									QC 21 - SA - 53		

Part Op 100 - (Hardinge)TURN AS PER FOLIO FA 868 AND DWG D4021 DWG REV: AA FOLIO
 Descriptions: REV: B ***MACHINE TO .375" MAX OD ***
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location:) LOCATION: WA004-5
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.375	304 Round Bar 0.375	4.0800 ft (.068 ea)	100-Hardinge - 1	5156620

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M304R0.375	4	38	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
2	Bushing	0.380Inches ± 0.030	0.410 0.350		
3	Bushing	0.750Inches ± 0.030	0.780 0.720		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Container No: S163160



Part: D4021-9

Job No: 191399

Serial No/Batch: S163160

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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